<b>Work Order</b> 2 May-09-14 8:28:17			*113	3158*						Page 1
Item ID: D3 Revision ID: Item Name: Shi	.442-5 m		Accept	*N900	<b>040</b>	100	ገ* ፡	Setup St	171	S1* S2*
	1/14 Start Qty: 24.00	*24* *24*		Cust Item l Customer:	D:				"IN	
	rocess Plan: MLT		Tooling: SPC (Y/N):		ate:		I	Run Sta St	op	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3442	Rev B									
*100 *100* Waterjet FLOW CNC Waterjet ろひは、ひらる	FLOW WATER JET  Memo  1-Cut as pe  Deburr if no	r Dwg D3442 Dwg Rev:_ ecessary	0.00  B 0.00 Prog Rev: 3	2			24	D		Jm14-05-12
110 *110* QC Quality Control	QC2- Inspect parts off n	nachine FAI/FAIB	0.00				24	٥		Jm14-05-12.
120 *1 20* QC	QC8- Inspect parts - sec	ond check	0.00 DAS 0.00 989	7			24			

Quality Control

DQA:			Date:										`	TQAG
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPD	DATE		_		AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
<b>14</b> / - O -						DISPOSITION				AGAINST DE	PARTMENT,	PROCESS		
Work Orde	r: -					Dawa ald	1		ماريم امنان	Canastuka		Water Jet	$\neg$	Engineering
Dort N	_					Rework	1		Skid-tube Machining	Crosstube Small Fab	Dro	d. Eng. Coor.		Engineering Quality
Part N	o. <b>-</b>					Scrap Use-as-is	┨Ì		noforming	Finishing	1	e/Packaging	$\dashv$	Other
NCR N	0					Suspected Unapproved	1	HIEH	~ <b>~</b>	Composite	Recystor	Supplier	$\dashv$	
I I I I I I I I I I I I I I I I I I I	٠. ـ					Suspected Gridpproved	ا ل		zuige i un		j	oappiie. [		Ш
Root	Т				Desci	ription of work order update	П	nitial	Action	n	Sign &			
Cause	-	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	tion	Date	Verification	۱	QC Inspector
Design														***
Doc/Data														
Equip/Tooling														
Handling/Pre			:				Ì							
Material														
Operator	╝													
Offset/Setup														
Process														
Supplier	_													
Training	_													
Transport	_												ļ	
Unapproved			1		<u> </u>		<u> </u>				L			
						_	FA	ULT CA	TEGORY					
Landin						General		11:- /6	Dua	_	Outside Dim	i-n- [	一,	Pressure/Forced
	_	Bending			$\vdash$	Bend	-	-1	Program	<b> </b>	Over/Under	F	_	Set-up
	$\dashv$	Centre No	ot Concer	itric	-	BOM/Route	-	Grain Hardwa			Part Incorre	· · · · · · · · · · · · · · · · · · ·	_	Temperature/Cure
	$\dashv$	Cracks Crimp/Kir	nlı/Dinnlo	Maria		Broken/Damage/Defect Burrs	$\vdash$	-i	are tion Incomplete/Ungi	ualified	Part Lost/Mi	- F	—	Weld
) <u> </u>	ᅱ	Cuffs	ik/ Kippie	, vvave	┢	Contamination	-	1 '	tions Incomplete/Und	<b>-</b>	Part Moved	331116	_	Wrong Stock Pulled
<b>! !</b>	-	Crushing			-	Countersink	$\vdash$	-	gned/off center	-	Positioned V	L Vrong	لـــا	ong otoek i uneu
	ᅱ	Heat Trea			-	Cut Too Short	$\vdash$	Mislab	•	<u> </u>	Power Loss/	- r		Other
	$\dashv$	Inspectio		Tube	$\vdash$	Drawing	-	Misrea		Ĺ	]	·· O- [		
	$\rightarrow$	Marks/Ch				Drill Holes	-	Off-set						
	$\dashv$	Turning S				Finish	_	4	Calibration		-			
		Wave/Tw	•			Fit/Function		-	Sequence					

<b>Work Orde</b> <i>May-09-14 8:28</i>		3158		*119	R158*							Page 2	
Revision ID:	D3442-5 Shim			Accept	*N900	<b>040</b>	100	)* ·	_	Start Stop	171	S1* S2*	
Start Date: Required Date: Reference:	2/11/14 2/11/14	Start Qty: 24.00 Req'd Qty: 24.00	*?		Cust Item I Customer:	D:							
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):		nte:		I		Start Stop		R1* R2*	
Sequence ID/ Work Center II	)	Operation Description Identify as per dwg & Stoo	ck Location: $\dot{m U}$	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	DAS
*130* Packaging		Memo *****STOCK	IN BASKET CEI	0.00 L*****				24	<b>K</b>	·	10	1-5-13	26 9-89

MLJ 1405-13 MLJ 1405-13

0.00

0.00

140

\*140\*

Quality Control

QC21- Final Inspection - Work Order Release

Memo

DQA:			Date:										JART.
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UF	PDATE			AEROSPACE
QA Closed:			Date:							W	ork Order up	date only	
						DISPOSITION			· · ·	AGAINST DE	PARTMENT	PROCESS	
Work Orde	r: _						,				7	14/-41-4	,
						Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	o. -					Scrap			Machining	Small Fab	4	d. Eng. Coor.	Quality
NICO NI	_					Use-as-is			noforming	Finishing	i Kec/Stor	e/Packaging Supplier	Other
NCR N	o. -				<del></del>	Suspected Unapproved	]		Large Fab	Composite	]	20ppilei [_	
Root					Desci	ription of work order update		nitial	Acti	on	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Design								<del></del>					
Doc/Data							İ						
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
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Transport	_								·		l	·	
Unapproved			<u>l</u>		<u> </u>		<u> </u>		<u> </u>				<u> </u>
							FA	ULT CAT	TEGORY				A
Landir					_	General		1		<del> </del>	7		٦
}		Bending			_	Bend	<u> </u>	4	Program	_	Outside Dim	<u> </u>	Pressure/Forced
]		Centre No	ot Concer	ntric	-	BOM/Route	$\vdash$	Grain			Over/Under	—	Set-up
]		Cracks				Broken/Damage/Defect	-	Hardwa			Part Incorre	<b>├</b>	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave	<u> </u>	Burrs	-	4 '	ion Incomplete/Un	· —	Part Lost/Mi	ssing	Weld
	_	Cuffs			<u> </u>	Contamination	$\vdash$	4	tions Incomplete/U	nciear	Part Moved	L V====	Wrong Stock Pulled
		Crushing			$\vdash$	Countersink	$\vdash$	- 1	gned/off center	<u> </u>	Positioned V		Other
		Heat Trea		<b>~</b> t	-	Cut Too Short	$\vdash$	Mislabe			Power Loss/	onige [	Other
		Inspectio	-	Tube	$\vdash$	Drawing	$\vdash$	Misrea					
		Marks/Ch			$\vdash$	Drill Holes	<u> </u>	Off-set					
		Turning S				Finish	-	-	Calibration				
1		Wave/Tw	ist in Tuk	oe .		Fit/Function	Ц.	Jout of	Sequence				

**Picklist Print** 

May-09-14 8:28:20 AM

Work Order ID: 113158

\*113158\*

Parent Item:

D3442-5

\*D3442-5\*

Parent Item Name: Shim

**Start Date: 2/11/14** 

Required Date: 2/11/14

Page 1

**Start Qty: 24.00** 

Required Qty: 24.00

**Comments:** 

IPP A05.09.02New issueKJ/JLM

IPP B 07.07.23 waterjet

EC

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No		100	sf	81.5670	0.025	1)			
*1.4004044	C							44				

\*M304516GA\*

304/316 Sheet .063

Location	Loc Oty	Loc Code	
MAT020	81.567		
M127821	78.567		
M128423	3		138433



DQA:			Date:			•							
						<b>WORK ORDER NON</b>	-CC	ONFO	RMANCE / UPE			. 💂	AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIU	٠					Rework	٦		Skid-tube	Crosstube		Water Jet	Engineering
Part I	Nο					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
''	•••					Use-as-is	1		noforming	Finishing	1	e/Packaging	Other
NCR I	No.					Suspected Unapproved	1 1		· —	Composite	·	Supplier	7
	•		-		_		-					. <del>-</del>	
Root					Desc	ription of work order update	I	nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
Design													
Doc/Data	Щ												
Equip/Tooling			1						:				
Handling/Pre		i										1	
Material	Ш												
Operator	Ш												
Offset/Setup	$\vdash$						1						
Process	<u> </u>												
Supplier	$\vdash$						1						
Training	$\vdash$										'		
Transport	$\vdash$		1										
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Land	ina (	Goor				General	FA	OLI CA	ILGONI				
Lanu		Bending				Bend	Г	Teolio/F	Program		Outside Dim	ensions [	Pressure/Forced
		Centre N	ot Conce	ntric		BOM/Route		Grain	108.4		Over/Under		Set-up
		Cracks	000000			Broken/Damage/Defect		Hardwa	are		Part Incorre	<b>-</b>	Temperature/Cure
		Crimp/Ki	nk/Ripple	/Wave	-	Burrs	$\vdash$	-{	ion Incomplete/Unq	ualified	Part Lost/Mi		Weld
	$\vdash$	Cuffs		,		Contamination		1 .	tions Incomplete/Un	<del>-</del>	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		-1	gned/off center	<del></del>	Positioned V	Vrong	<u> </u>
1		Heat Trea				Cut Too Short		Mislab	<u>-</u>		Power Loss/	Surge	Other
		Inspectio		Tube		Drawing		Misrea	d				
		Marks/Cl				Drill Holes		Off-set					
		Turning S	Sequence			Finish		Out of	Calibration				
		Wave/Tw	vist in Tul	oe e		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	113158
Description: 5HIM	Part Number:	03443-8
Inspection Dwg: ∫3442 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	11-0.030"	1.0034			V	Jamos
2.50"	~	2,505			J	
0.75	مر	0.753			V	
0.75	tl-0:015	0.062			$\mathcal{L}$	
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<u> </u>	<u> </u>		DAS			

Measured by: Jm	Audited by:	27 9-89 )	Preliminary Approval:
Date: 14-05-10	Date:	14/5/1P	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15

